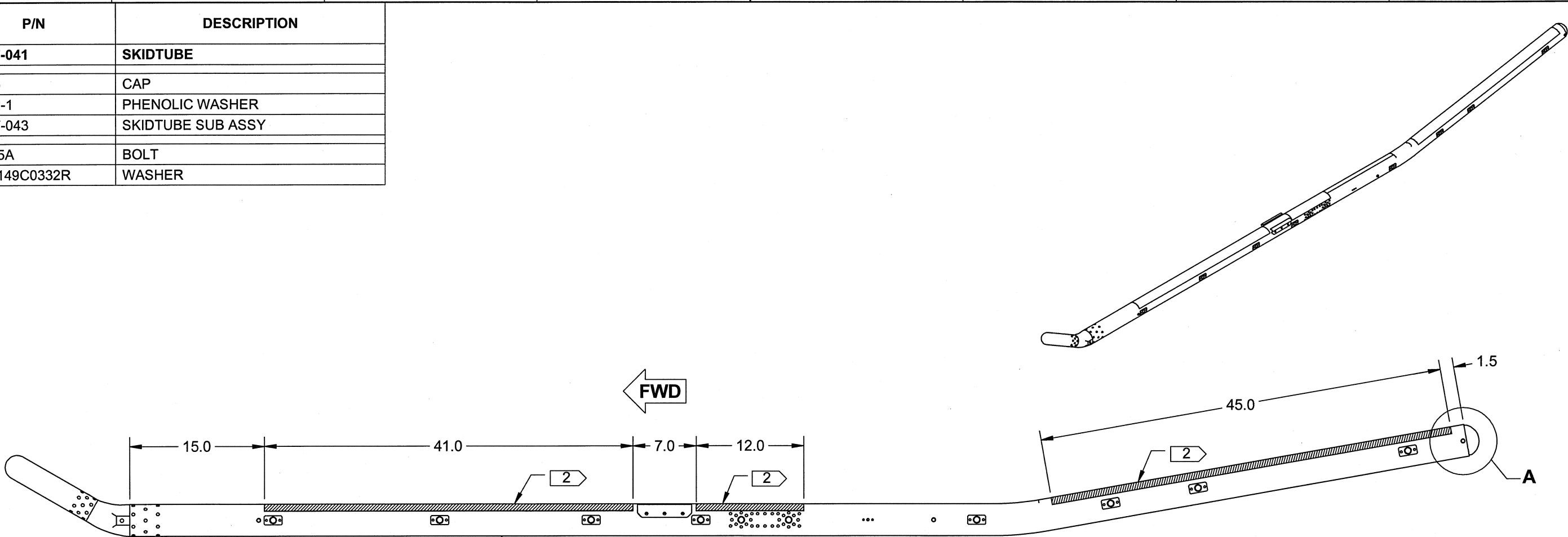
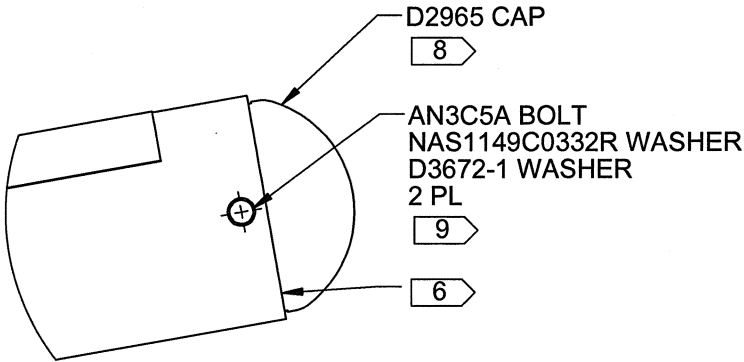


| QTY -041 | P/N | DESCRIPTION |
|-------------|---------------|-------------------|
| X | D5657-041 | SKIDTUBE |
| 1 | D2965 | CAP |
| 2 | D3672-1 | PHENOLIC WASHER |
| 1 | D5657-043 | SKIDTUBE SUB ASSY |
| 2 | AN3C5A | BOLT |
| 2 | NAS1149C0332R | WASHER |



D5657-043 SKIDTUBE SUB ASSY

D5657-041 SKIDTUBE



DETAIL A
SCALE 4X

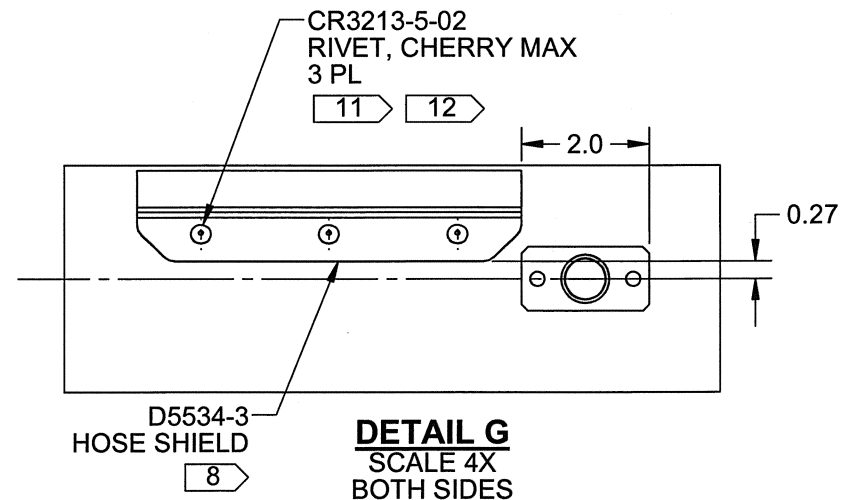
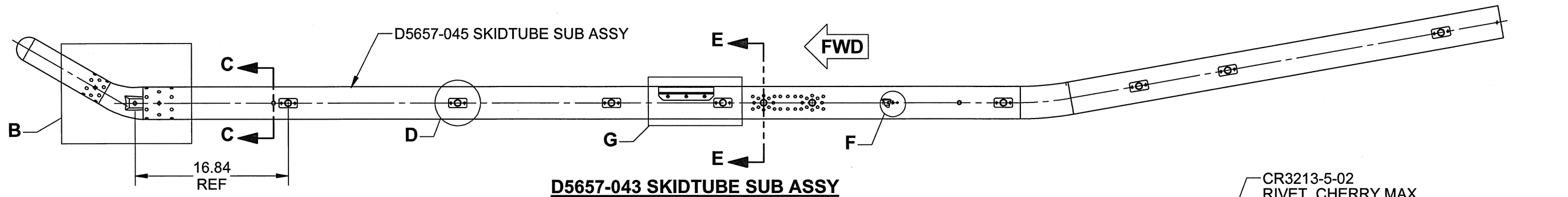
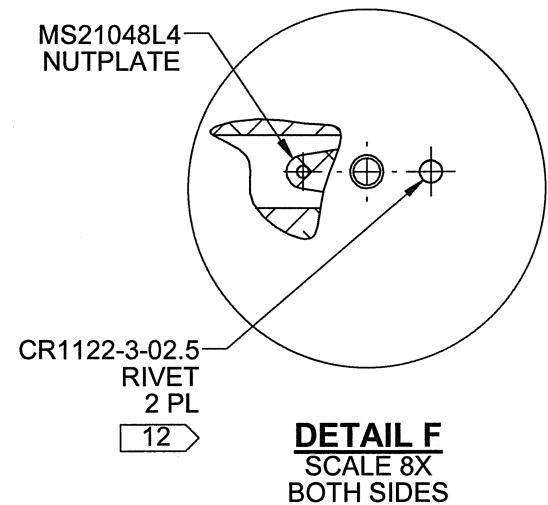
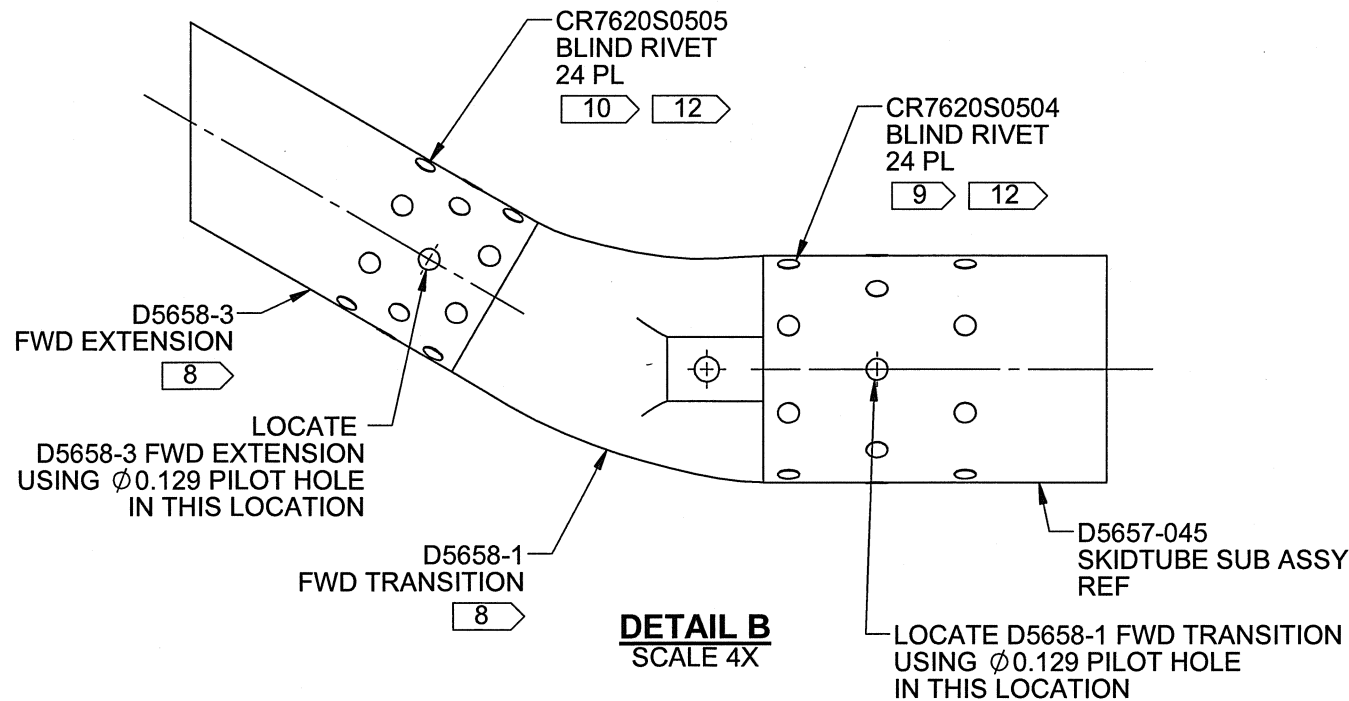
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) PER DART QSI 005 4.4 IN LOCATIONS SHOWN TO 1.00 ABOVE CENTERLINE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: SCRIBE DART P/N "D5657-041" AND S/N PER DART QSI 044 6.4 ON INNER RADIUS OF AFT END OF TUBE BEFORE INSTALLING CAP
 - 7) WEIGHT: 38.0 lbs
 - 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT
 - 9) WET INSTALL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 SEALANT

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2019 SEP 10
ECM9-890

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| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | ZF | 18.11.30 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ZF | DART AEROSPACE USA, INC. HILLSBORO, OR | |
| DRAWN | MW | | |
| CHECKED | ZF | DRAWING NO. | REV. A |
| MFG. APPR. | DD | D5657 | SHEET 1 OF 6 |
| APPROVED | NO | TITLE | SCALE |
| DE APPR. | DS | SKIDTUBE | NTS |
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| QTY -043 | P/N | DESCRIPTION |
|-------------|---------------|-------------------|
| X | D5657-043 | SKIDTUBE SUB ASSY |
| 8 | D4686-1 | SPACER |
| 16 | D4753-1 | DOUBLER |
| 2 | D5304-1 | CROSSBOLT SPACER |
| 2 | D5534-3 | HOSE SHIELD |
| 1 | D5657-045 | SKIDTUBE SUB ASSY |
| 1 | D5658-1 | FWD TRANSITION |
| 1 | D5658-3 | FWD EXTENSION |
| 4 | AELS-1032-130 | INSERT |
| 4 | AN3C4A | BOLT |
| 4 | CR1122-3-02.5 | RIVET |
| 6 | CR3213-5-02 | RIVET, CHERRY MAX |
| 24 | CR7620S0504 | BLIND RIVET |
| 24 | CR7620S0505 | BLIND RIVET |
| 32 | MS20601AD4W3 | RIVET, BLIND, CSK |
| 2 | MS21048L4 | NUTPLATE |
| 4 | NAS1149C0332R | WASHER |

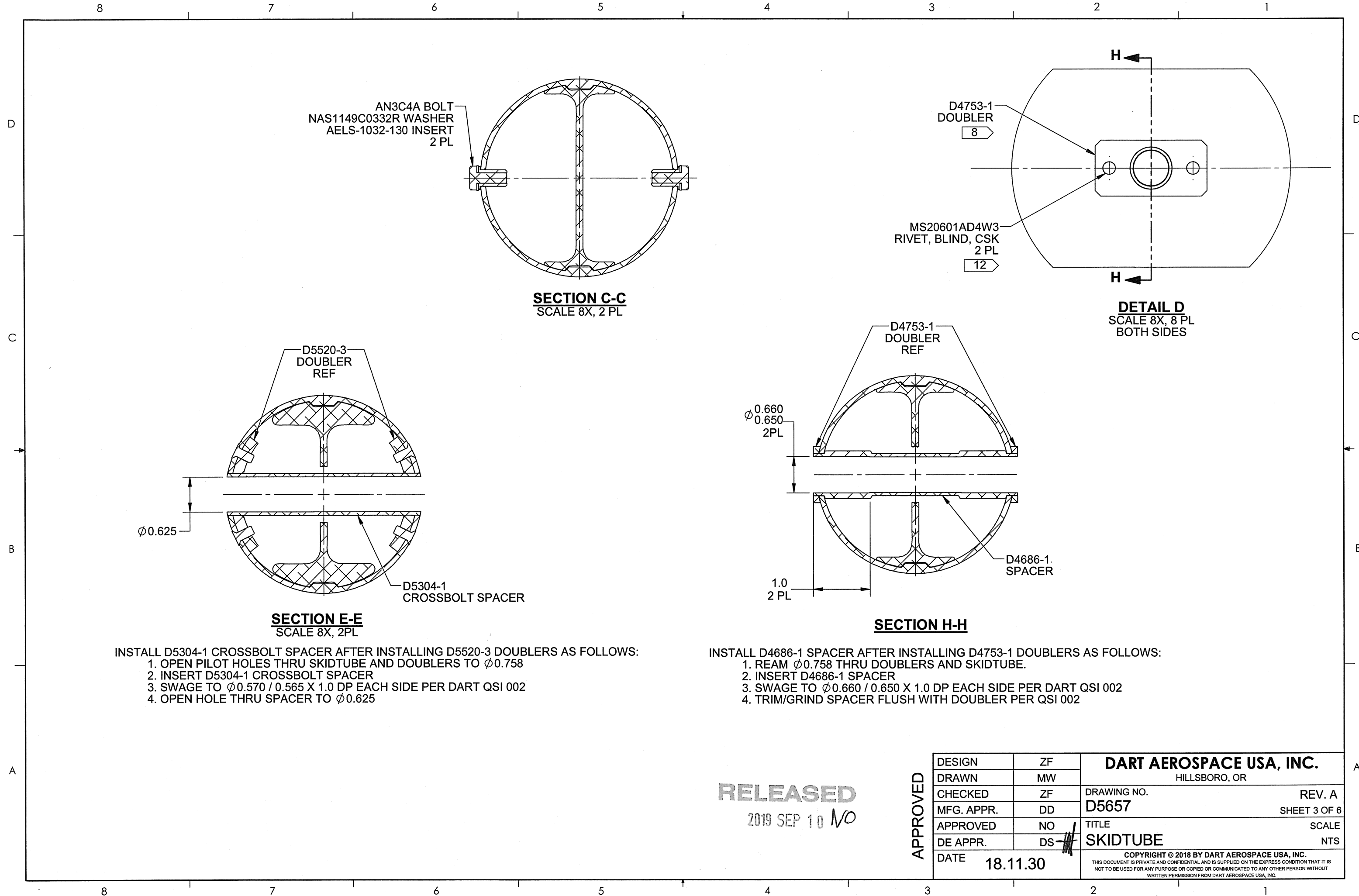


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 36.9 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT
 - 9) TRANSFER DRILL QTY (24) $\phi 0.129$ (#30 DRILL) HOLES FROM SKIDTUBE TO D5658-1 FWD TRANSITION
OPEN HOLES THRU SKIDTUBE AND D5658-1 FWD TRANSITION TO $\phi 0.164 / 0.167$, COUNTERSINK THE SKIDTUBE HOLES TO $\phi 0.327 / 0.335 \times 100^\circ$
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
INSTALL D5658-1 FWD TRANSITION USING CR7620S0504 RIVETS
 - 10) TRANSFER DRILL QTY (24) $\phi 0.129$ (#30 DRILL) HOLES FROM D5658-3 FWD EXTENSION TO D5658-1 FWD TRANSITION
OPEN HOLES THRU D5658-3 FWD EXTENSION AND D5658-1 FWD TRANSITION TO $\phi 0.164 / 0.167$
COUNTERSINK THE D5658-3 FWD EXTENSION HOLES TO $\phi 0.327 / 0.335 \times 100^\circ$
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
INSTALL D5658-3 FWD EXTENSION USING CR7620S0505 RIVETS.
 - 11) LOCATE AND TRANSFER MARK HOLES FROM D5534-3 HOSE SHIELD TO SKIDTUBE. DRILL QTY (3) $\phi 0.161$ HOLES THRU SKIDTUBE.
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
INSTALL D5534-3 HOSE SHIELD AFTER FINISH WITH CR3213-5-02 RIVETS.
 - 12) WET INSTALL RIVETS USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT.

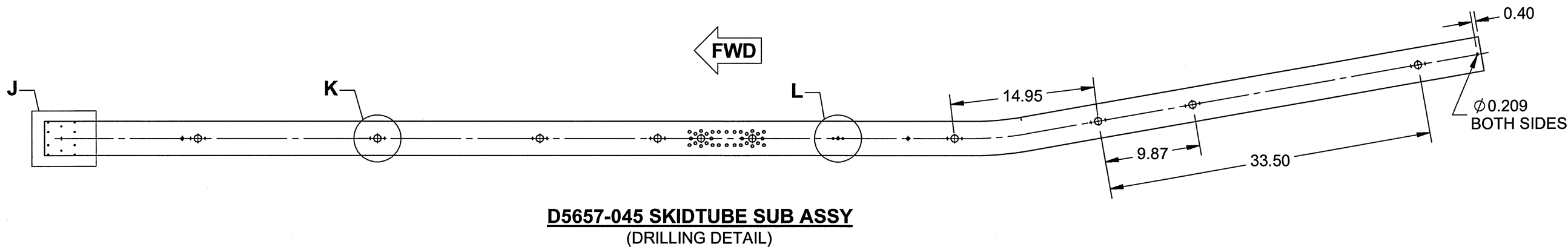
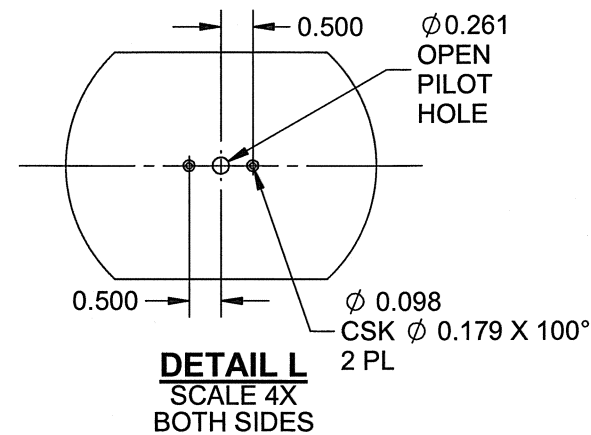
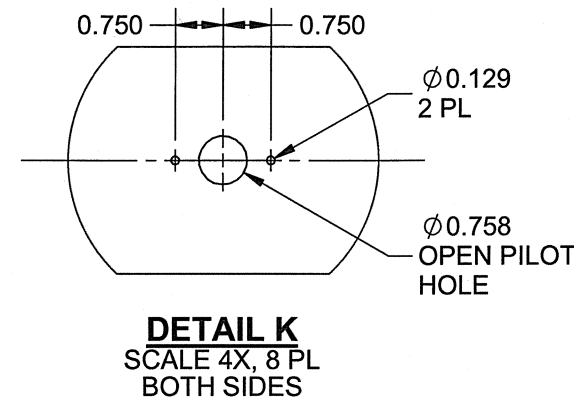
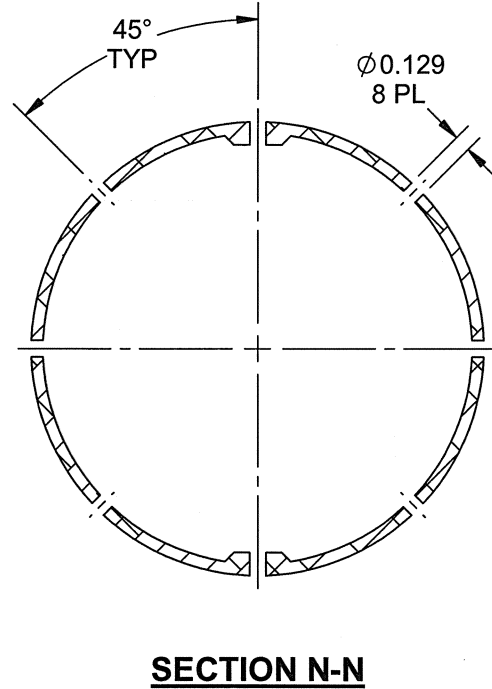
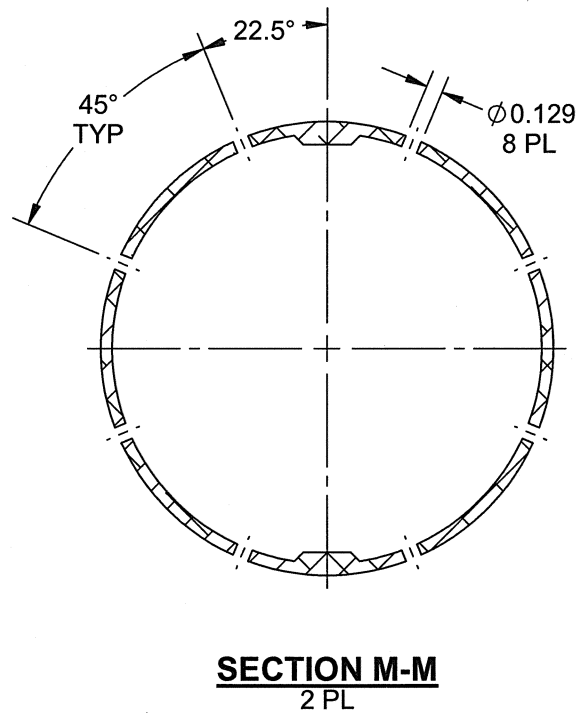
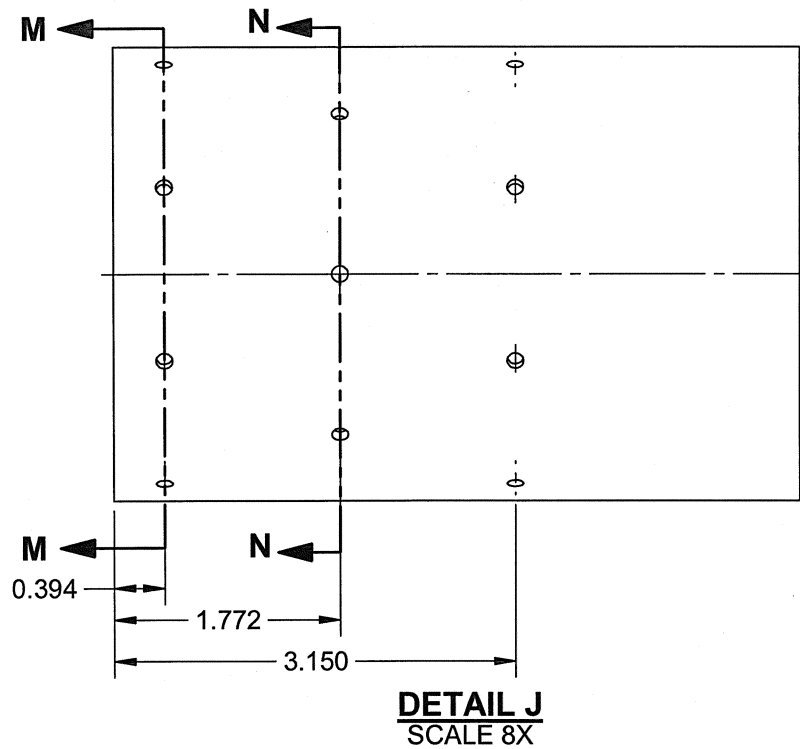
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| MFG. APPR. | DD | D5657 | SHEET 2 OF 6 |
| APPROVED | NO | TITLE | SCALE |
| DE APPR. | DS | SKIDTUBE | NTS |
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| QTY -045 | P/N | DESCRIPTION |
|-------------|-------------|-----------------------|
| X | D5657-045 | SKIDTUBE SUB ASSY |
| 1 | D5657-1 | SKIDTUBE |
| 1 | D5085-1 | WEB |
| 2 | D5520-3 | DOUBLER |
| 60 | CR3212-5-05 | CSK RIVET, CHERRY MAX |

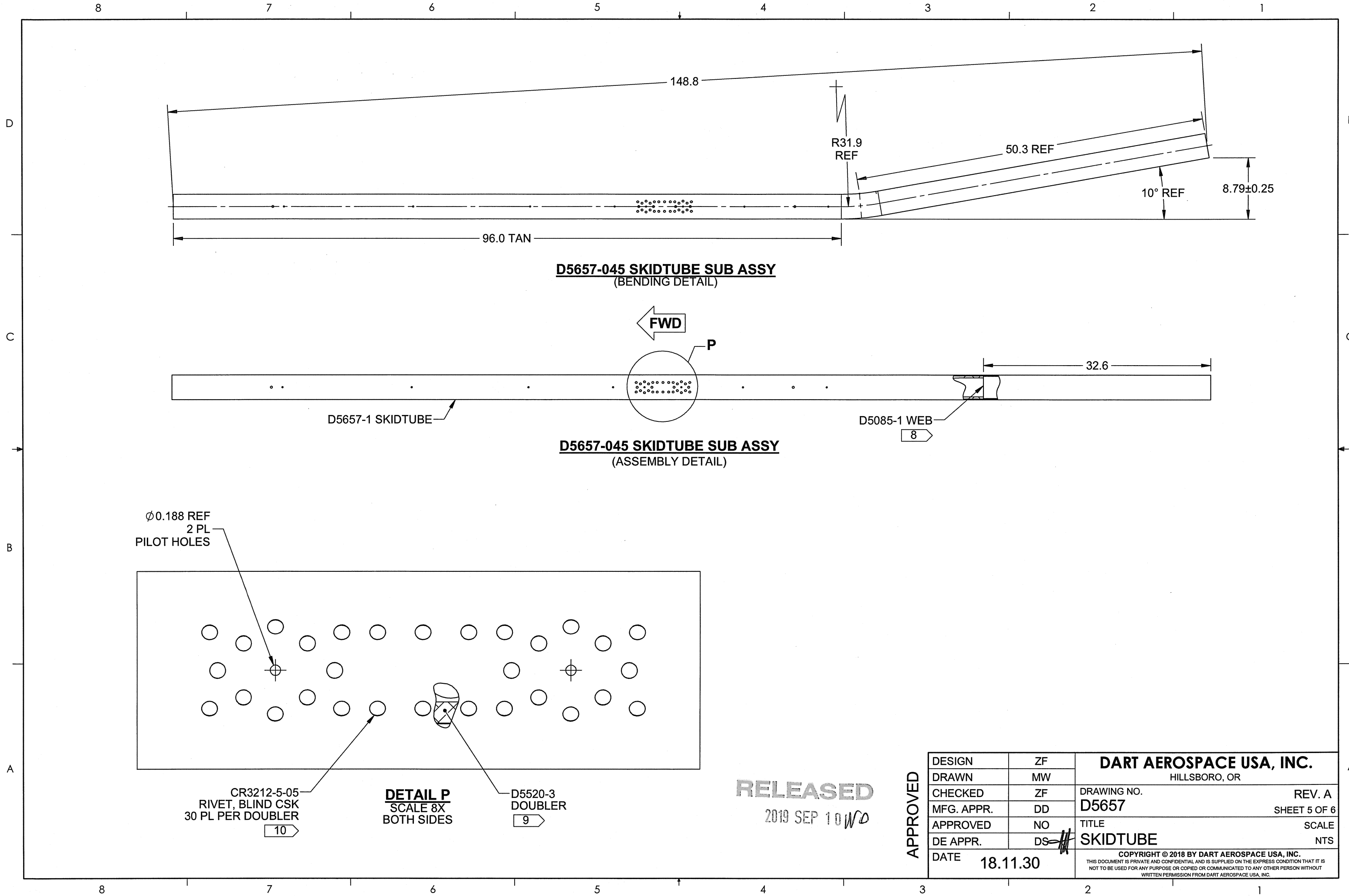


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 31.0 lbs
 - 8) INSTALL WEB ASSY INTO SKIDTUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015, LOCATE AS SHOWN
 - 9) LOCATE THE D5520-3 DOUBLER USING THE 0.188 PILOT HOLES IN THE SKIDTUBE AND DOUBLER
 - 10) DRILL QTY (30) 0.160 / 0.164 (#20 DRILL) HOLES THRU SKIDTUBE AND D5520-3 DOUBLER USING TOOL DT 10481
- COUNTERSINK THE SKIDTUBE HOLES TO 0.283 / 0.289 X 100°
DEBURR HOLES AND TOUCH-UP WITH CHEMICAL FILM (ALODINE 1200) PER MIL-DTL-5541
INSTALL DOUBLER USING CR2312-5-05 RIVETS
WET INSTALL RIVETS USING PROSEAL 890/1422 OR MIL-S-8802 SEALANT

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D5657-045 SKIDTUBE SUB ASSY
(BENDING DETAIL)

D5657-045 SKIDTUBE SUB ASSY
(ASSEMBLY DETAIL)

DETAIL P
SCALE 8X
BOTH SIDES

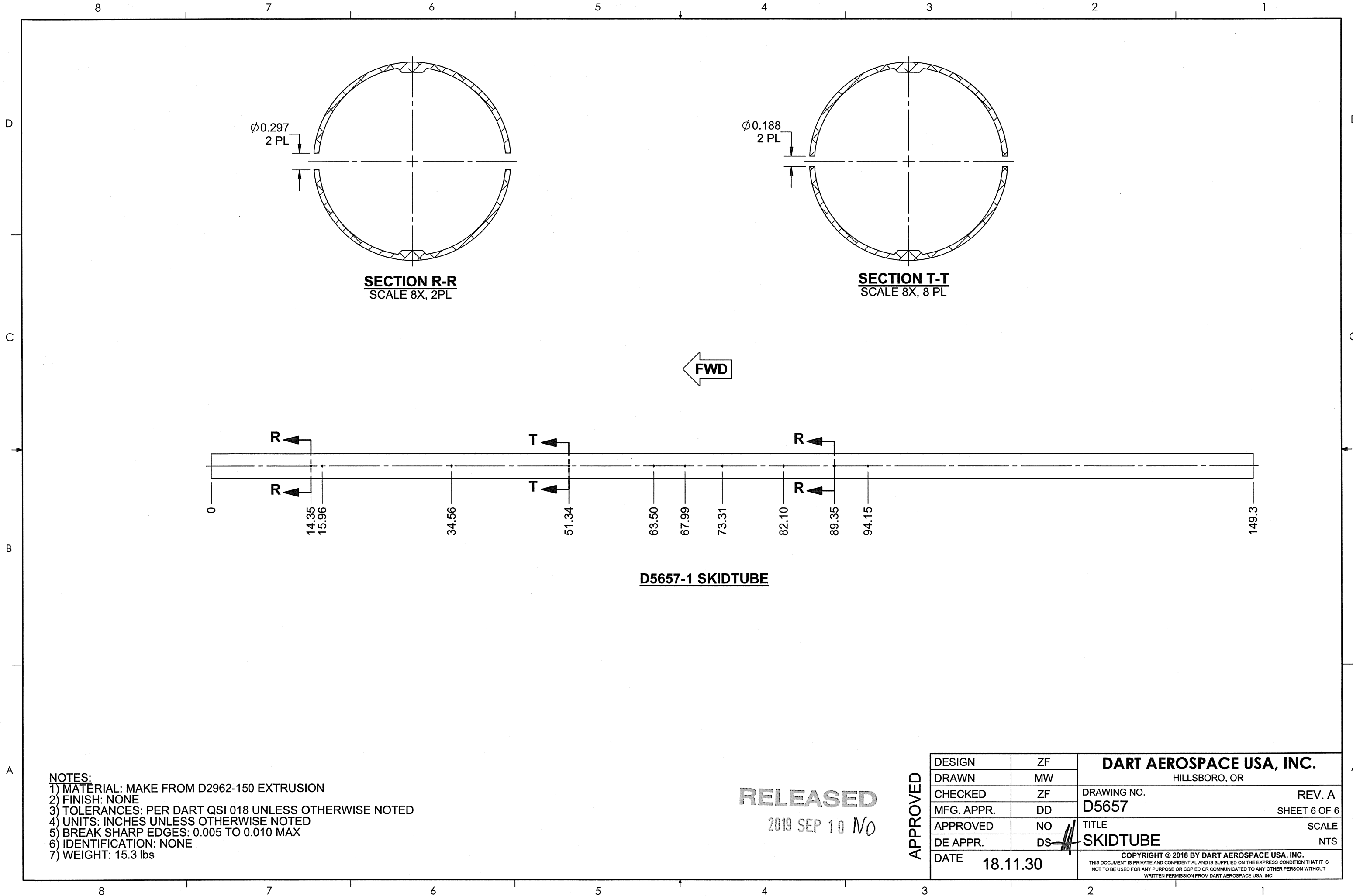
D5520-3
DOUBLER

CR3212-5-05
RIVET, BLIND CSK
30 PL PER DOUBLER

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| MFG. APPR. | DD | D5657 | SHEET 5 OF 6 |
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- NOTES:
- 1) MATERIAL: MAKE FROM D2962-150 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 15.3 lbs

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| MFG. APPR. | DD | SHEET 6 OF 6 | |
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